DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026205
Date Inspected: 18-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 630
OSM Departure Time: 1500
Location: Santa Fe Springs, CA

CWI Name:	Ruben Dominguez			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006 L & R
Component: Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

E2/E3 Bike Path Traveler

This QA Inspector made random shop observations and observed no fit-up performed on the E2/E3 Bike Path Traveler Assemblies on this date.

SAS-WB Traveler – Lower Truss Frame Assembly

Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on Thursday 5-12-11. Quality Control Mr. Dominguez informed QA Inspector that Smith Emery did complete visual inspection and waiting on WMI to weld and grind on some area's found by visual inspection. Grinding not completed on this date.

E2/E3-WB Traveler (South)

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed

Mr. Rodriguez performing the FCAW in all positions randomly throughout the shift.

SAS-WB Traveler - Fixed Stair Section
This QA Inspector made random shop observations and observed no fit-up performed on the SAS-WB Traveler - Fixed Stair Section on this date.

E2/E3-WB Traveler (North)
This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the E2/E3 Traveler Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

RPI Coating (Blast and Paint)
This QA Inspector performed random shop observations and observed that RPI is on site to continue with painting activities. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Miguel Nunez that RPI will be applying a mist coat using the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane to trolley links today. QA Inspector randomly observed RPI Coating in the process of applying mist and final coat throughout the day on the trolley link assemblies. Environmental readings taken by RPI at the time of the mist and final coating applications are as follows: Air Temperature 70 F/76 F, Relative Humidity 70%/56%, Wet Bulb Temperature 62 F/65 F, Dew point 59 F/60 F and Surface Temperature 69 F/77 F. Mr. Miguel Nunez informed QA Inspector his helper will continue sanding and pressure washing also today. QA Inspector randomly RPI personnel hand sanding prime coated links using 100grit sandpaper and pressure washing links using a 6000 psi pressure washer.

Later in the morning this QA Inspector randomly observed that RPI personnel performing abrasive blasting

activities on the Trolley links assemblies. After abrasive blasting was completed, QA Inspector then observed QC Mr. Nunez performing surface profile check on the abrasive blasted base metal surfaces. QA Inspector observed Mr. Nunez utilizing Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.2 mils. This QA Inspector noted surface profiles appear to with contract documents.

Mr. Nunez informed QA Inspector that on the interim coating using the Sherman Williams Zinc Clad II, Inorganic Zinc Rich prime coating he would be performing ASTM D3363 Film Hardness by Pencil Test, ASTM D4752 Measuring MEK Resistance to Ethyl Silicate (Inorganic) Zinc-Rich Primers by Solvent Rub and performing the Quarter test. Mr. Nunez stated that he will be using Sherman Williams R7 KIII High Solids compliant thinner #1 for the solvent rub test. Testing observed by QA Inspector appeared to comply with contract documents.

This QA Inspector performed measurement on dry film thickness (DFT) with Type 2 (magnetic gage), DFT's thickness reading of the top coat on trolley link assemblies top coated using the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane on 08-17-11are an average of three (3) thickness reading are as follows 9.9 mils, 9.8 mils, 8.7 mils, 12.9 mils, 8.5 mils, 10.0 mils, 8.5 mils, 10.1 mils, and 12.2 mils. QA Inspector was informed by Mr. Nunez that RPI will be touching up areas that have dry film thickness reading lower than 8.5 mils using a paint roller. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brannon,Sherri Quality Assurance Inspector

WELDING INSPECTION REPORT

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Reviewed By: Lanz,Joe QA Reviewer